

Work Order ID 81969

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81969

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Item ID: D3067-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Plate
 Start Date: 21/03/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3067	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 B12-4-8
 FLOW CNC Waterjet 1-Cut as per Dwg D3067
 5053 .063 Dwg Rev: A
 Prog Rev: A (75)
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00 H312-4-8
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 8026105
 Quality Control

ccub
 (74e) u P10

W/O: 81969		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D30627 PAR #: _____ Fault Category: Small Part / Work Set NCR: Yes No DQA: [Signature] Date: 12/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/4/23

NCR: 12-1362		WORK ORDER NON-CONFORMANCE (NCR) 2.14						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/27	#120	Qty of Part Bent when passing through the Deburin machine LC Process	[Signature] 05/04/27	Scrap + Destroy no Repair Qty of 1	12/4/23	[Signature] 12/04/23	[Signature] 05/04/27	[Signature] 12/04/23

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3067								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>WNA</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL ***								

Sf 12/04/13

cents

8.7/04/13

74

φ

12.04.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81969***81969***

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Item ID: D3067-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: End Plate

Stop ***NS2***

Start Date: 21/03/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

YMF
12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81969

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Parent Item: D3067-1

D3067-1

Parent Item Name: End Plate

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

76.8526

0.0625

3.947368

51

M5052H32S 063

**

B12-4-8

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

76.852632

114322

12.852632

120603

64

120603

75

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

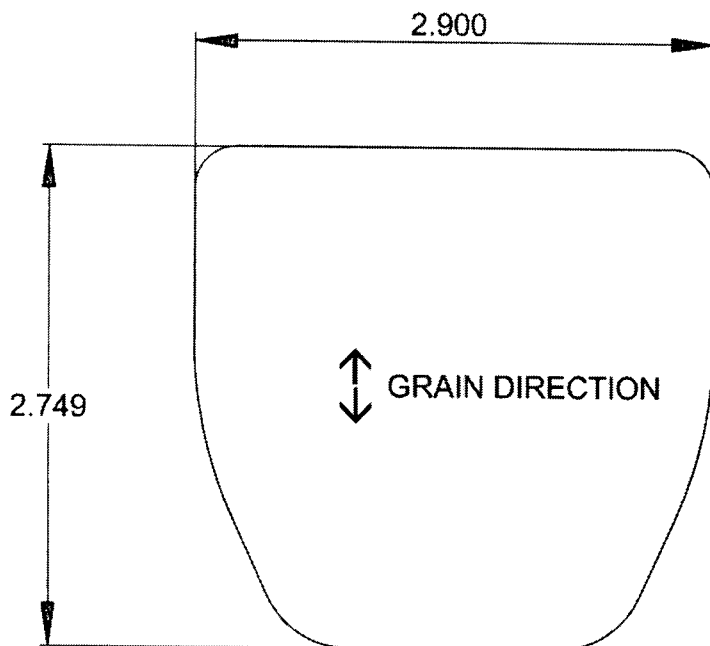
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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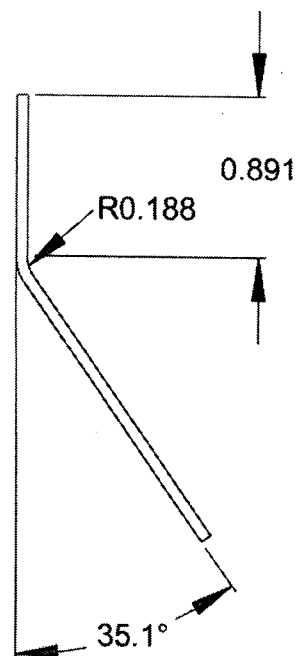


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE END PLATE		SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81909 MCT
12/03/21

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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